

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029051**Date Inspected:** 29-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** USA Hoist, Crest Hill, IL

CWI Name:	Robert Zimny		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** SAS Tower Elevator**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at USA Hoist, Crest Hill, IL as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At USA Hoist assembly shop, this QA randomly observed USA certified welder Genaro Ulloa continuing to perform 1G (flat) position gas shielded Flux Cored Arc Welding (FCAW-G) welding Complete Joint Penetration (CJP) T-joint between C-channels C200 x 20.5/C180 x 18.2 x 2106mm long part numbers 914930/914911 and angular 6.4 x 6.4 x 9.5 x 1800mm long part number 914900-02. The C200 x 20.5 channel is being welded on the left side of the 6.4 x 6.4 angular while the C180 x 18.2 channel is being welded on the right side. These channels to angle connections are intended for door enclosure frame for elevator stops at 1 (elevation 15 meter), stop 4 (elevation 127.85 meter) and stop 5 (elevation 139.85 meter). During the shift, Mr. Ulloa has completed CJP T-joint welding the third door enclosure frame for the three stops as mentioned above. That should complete the three identical frames.

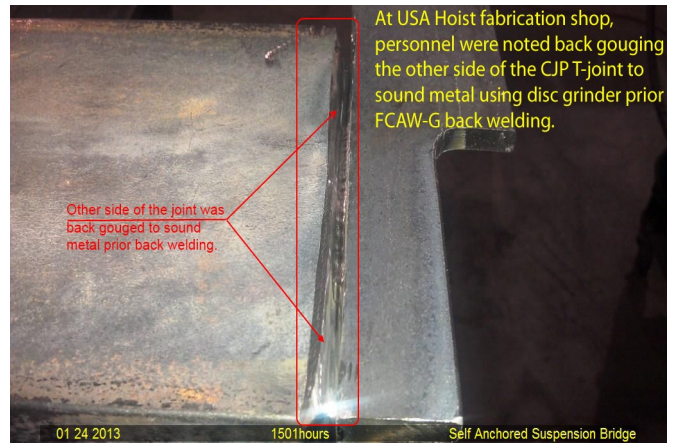
After completing the door enclosure frames for stops 1, 4 & 5, Mr. Ulloa continued CJP T-joint welding the third door enclosure frame for stops 2, 3 & 6. This third enclosure was previously welded by Mr. Matt Wasiqi but was not completed. Mr. Ulloa performed back gouging on the T-joints using disc grinder and then let this QA perform visual check on the gouging to sound metal prior to back welding.

The welder was noted using gas shielded FCAW-G with 1.1mm E71T-1C Familiarc DW-50 wire electrode implementing USA Hoist Welding Procedure Specification FCAW 2916. The shielding gas being used was noted

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

a combination of 75% Argon and 25% CO2 with flow rate of 35 CFH. During the shift, the working welding parameters was measured 28 volts and 225 amperes which deemed in compliance to the project requirements. At the end of the shift, two (2) of the three (3) identical frames for the six stops were completed.



Summary of Conversations:

There is no significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer
